

Work Order ID 83189

83189

Page 1

April-13-12 1:00:57 PM

Item ID: D3779-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate

Start Date: 13/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3779	B

4

100 0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

B12-G-26

FLOW CNC Waterjet

1-Cut as per Dwg D3779

6061 .050

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110 0.00

QC2- Inspect parts off machine FAI/FAIB

110

QC

Memo

0.00

B12-G-26

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 27/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Date:

Run Start

NR1

QC: Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

5/17/2012

(X)

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

4 NG 12-6-27

Hand Finishing

140

QC7- Inspect Part Finish

0.00

140

QC

Memo

0.00

12/4/27 (4)

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 3

April-13-12 1:00:57 PM

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Accept

N900040100

Setup Start

NS1

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Stop

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Item Name: Plate

Start Date: 13/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: STL62 0.00

150

Packaging

Memo

0.00

4X

12-6-27

Packaging

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.00

12/6/28

ME

12-06-27

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-13-12 1:01:01 PM

Page 1

Work Order ID: 83189

83189

Parent Item: D3779-3

D3779-3

Parent Item Name: Plate

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	245.7940	0.1937	0.815579			

M6061T6S 050

**

B 12-6-20

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

021

144

1211920

144

MAT021

101.794

113216

10

114799

76.794

114993

15

114799

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

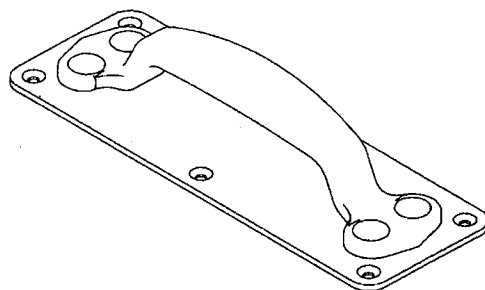
NOTE: Date & initial all entries

QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-9	RIVET, CSK

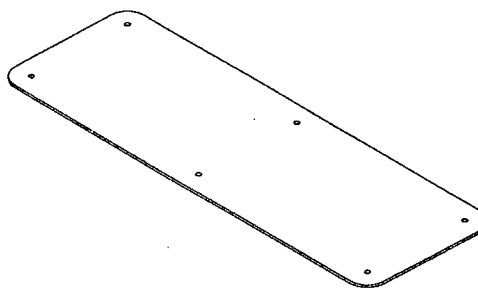
△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

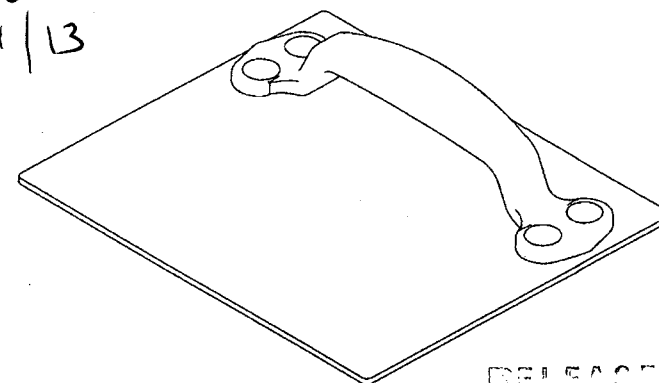
NO. 83185 MCT
12/04/13



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-3 DOUBLER PLATE



D3779-043 HANDLE ASSEMBLY
(INTERIOR)

RELEASED
2011-12-01

B	REFORMAT IAW DART QSI 043; MS20426AD10-9 WAS MS20426AD10-8 (ZN D6-1, B8/B4-2). REASON: PRODUCTION FACILITY (PAR11-138).		MB	11.11.24
A	NEW ISSUE		AJS	08.04.21
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	[Signature]		DRAWING NO. D3779	
CHECKED	[Signature]		REV. B	
MFG. APPR.	[Signature]		SHEET 1 OF 4	
APPROVED	[Signature]		TITLE HANDLE ASSEMBLY, SCALE	
DE APPR.	[Signature]		CABIN SLIDING DOOR NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

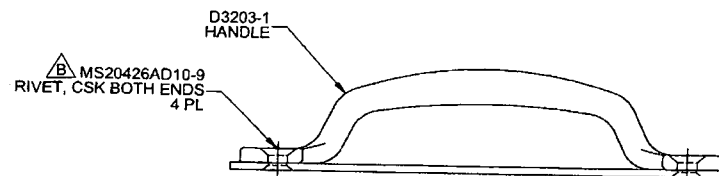
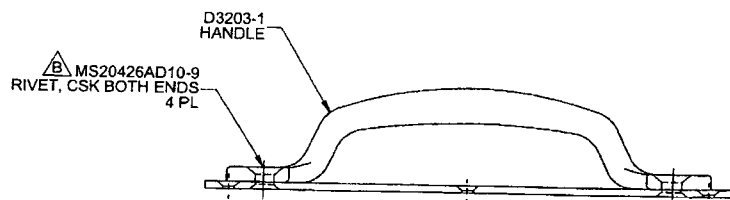
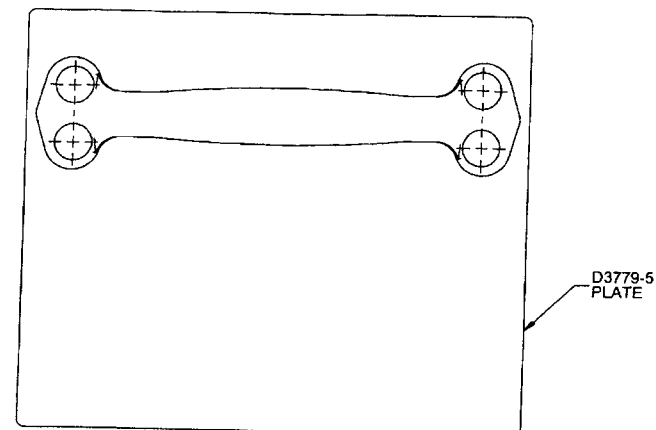
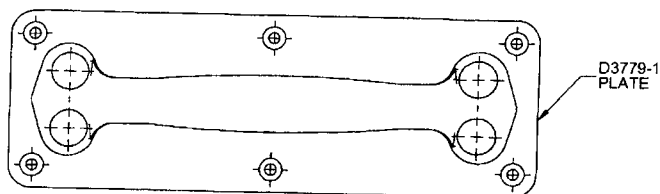
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

83289








D3779-041 HANDLE ASSEMBLY
(EXTERIOR) [6.8]

D3779-043 HANDLE ASSEMBLY
(INTERIOR) [7.9]

RELEASED
2011-12-01

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3779	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	11.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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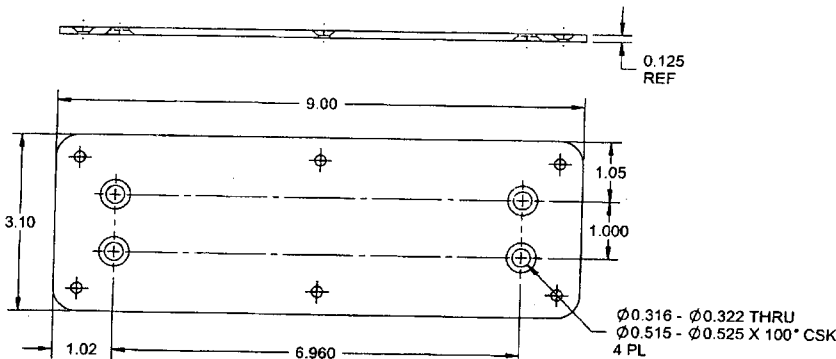
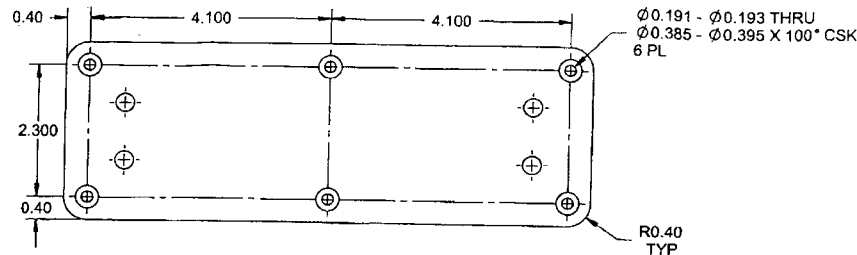
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

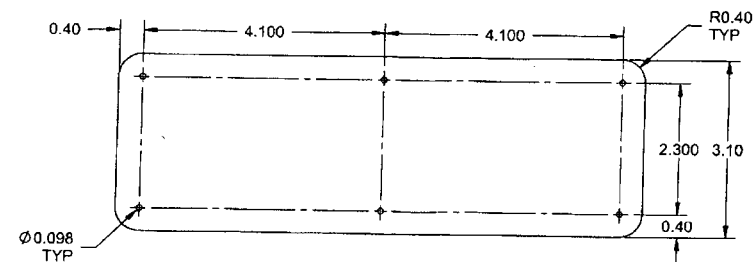
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3779-1 PLATE



D3779-3 PLATE

NOTES:

- 1) MATERIAL: -1 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
- 3 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY D3779-3 WITH DART P/N "D3779-3" AND B/N "BXXXXX" PER DART QSI 044 6.1 (PERMANENT PAINT MARKER)
(DO NOT IDENTIFY D3779-1)
- 7) WEIGHT: 0.14 lbs FOR -3

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3779	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DATE	11.11.24	NTS	
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2011-12-01
JW

83189

W/O:		WORK ORDER CHANGES					
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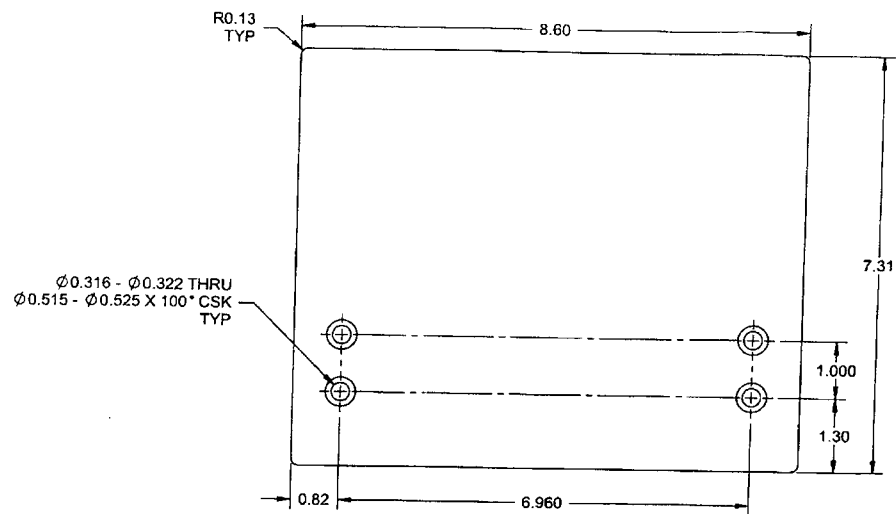
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

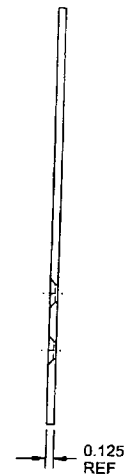
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NOTE: Date & initial all entries

83189



D3779-5 PLATE



NOTES:

- 1) MATERIAL: -5 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

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2011-12-01

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MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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